

Work Order ID 82686

82686

Page 1

April-04-12 1:58:42 PM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: 12/04/03

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

0.00

100

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

S. J. J.

CAF MCS 12-6-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500" deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

JP 12-04-12

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Date:

Tooling:

Date:

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QC:

Date:

SPC (Y/N):

Date:

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Work Center ID

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Description

Set Up/
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Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: *M120854 86 12/04/19*

12-Grind welds flush as per Dwg D2750

SAP 12-04-19

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

Sizler

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

Sizler

W/O:		WORK ORDER CHANGES					
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QC: Date: SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI015 A/R Sikaflex-291 batch: <u>12/221</u> exp. date: <u>13/01/04</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M120854</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

DC 12/04/23

DC 12/04/23

380 12/04/24

12-05-01

SAD/CC 12-5-1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Cust Item ID:

Start Date: 04/04/2012 **Start Qty:** 1.00

*** 1 ***

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Required Date: 18/04/2012 **Req'd Qty:** 1.00

*** 1 ***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Skidtube RH

Stop *NS2*

Start Date: 04/04/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00				<u>26</u>	<u>12-5-3</u>		
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <u>1:40</u> OVEN TEMPERATURE: <u>3200F</u> FINISH TIME: <u>2:10</u>	0.00 0.00				<u>IX</u>	<u>12/05/03</u>		
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00				<u>1RH</u>	<u>12/05/04</u>		

m. 21134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NS1

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Item Name: Skidtube RH

Stop

NS2

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00

230

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"

batch: N/A

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 121221

EXP DATE: 13/01

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 110348

6-Coat all exposed fasteners with "LPS Procyon"

batch: 114596

1 8 29 12/05/04
RH
Pto →

W/O: 82686		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-012 PAR #: _____ Fault Category: Spd tube NCR: Yes No DQA: OK Date: 12/07/04
 Resolution: _____ Disposition: Repair scrap QA: N/C Closed Date: 12/7/5

NCR: 12-1561		WORK ORDER NON-CONFORMANCE (NCR) 1916-34						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/03	# 230	Found during Assembly that D3488-04/42 Doesnt Align with SKID tube. PL tol on D3488-04/42 and Hummer Drill of SKID (Process)	CP 12.06.04	Drill at x5 aft most holes to max tol. in SKID Drill at x5 holes to max tol on D3488	12-6-04	12-06-03	CP 12.06.04	S 12/06/03
			CP 12.06.04	touch up holes with alodine as per DSZ.005 + re assembly holes drilled over sizes - screw + destroy as per DS. Recommendation	12/06/04 X1	12-06-02	CP 12.06.04	S 12/06/03
				Reple D3488-042 B 83417	12/06/04 X1			

NOTE: Date & initial all entries

Work Order ID 82686

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				18/4	12-06-22		
250 *250* Packaging Packaging	Pick Kit Memo	0.00 0.00							
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH

Stop *NS2*

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging	0.00							
Packaging	Memo								
Packaging	Package as per PPP D350-636-012								
280		0.00							
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo								
Quality Control									

Rev 5

Loc 72

X

12-6-26

12/6/27

umf
12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 82686

82686

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: I02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
 IPP Rev: N 08-09-23 rev F as per dwg DD verified by: ec IPP Rev: O
 10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as
 per IIN rev H DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured

No

110

Each

15.0000

1

1

D2600-3-BENT

Extrusion Bent

893305

**

① 12-04-19

Location

Loc Qty

Loc Code

LG

15

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

D2744

Manufactured

No

110

Each

46.0000

1

1

D2744

Cap

**

BE12-04-19

Location

Loc Qty

Loc Code

LG002

46

62715

1

70881

3

78900

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D350-636-012

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160 Each

5.0000 1 1

D2739

350 I Beam

**

DC 12/04/23

Location

Loc Qty

Loc Code

LG

B83548

5

72155

1

81508

1

82122

3

(P)

D2743

Manufactured No

160 Each

346.0000 8 8

D2743

Crossbolt Spacer

**

BE 12/04/24
B 81965 *8

Location

Loc Qty

Loc Code

LG001

346

67766

4

68251

3

73403

64

74445

1

78603

2

79517

62

D3490-3

Manufactured No

160 Each

90.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE 12/04/24

Location

Loc Qty

Loc Code

LG

88

82016

88

LG001

2

78800

2

4

April-04-12 1:58:45 PM

Shop Packet Print

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH

82686

D350-636-012

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

30.0000

1

1

D3793-3

Wearshoe

**

1 (DP) 12/05/04

Location

Loc Qty

Loc Code

FP001

23

80434

11

82166 ✓

12

FP002

7

78935

7

MS21043-6

Purchased

No

230

Each

773.0000

4

4

MS21043-6

NUT

**

4 (DP) 12/05/04

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

753

112314

47

117887

6

118384 ✓

200

120308

500

D3794-1

Manufactured

No

230

Each

16.0000

1

1

D3794-1

Gasket

**

1 (DP) 12/05/04

Location

Loc Qty

Loc Code

FP002

16

~~82166~~ ✓
75042

4

80435

12

82167 ✓

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Shop Packet Print

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D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

275.0000

8

8

NAS1611-010

O-RING

**

8 8 12/05/04

Location

Loc Qty

Loc Code

FP	12145 ✓	50
	110915	0
	120770	50
FP001		225
	110915	14
	117460	8
	118077	1
	118612	3
	119438	47
	120986	50
	121166	52
	121259	50

D2741

Manufactured

No

250

Each

67.0000

1

1

D2741

Blade, 350 Skidtube

**

83130

Location

Loc Qty

Loc Code

ST		-10
ST466		77
	71856	1
	76984	26
	79516	40

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Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 6

Work Order ID: 82686

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

82686

D350-636-012

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

198.0000

4

4

***NAS1515H3I ***

WASHER

**

4 (2P) 12/05/04

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

158

118686

3

119438

1

120072

8

120360

96

121243 ✓

50

NAS1611-013

Purchased

No

230

Each

250.0000

8

8

NAS1611-013

O-RING

**

8 (2P) 12/05/04

Location

Loc Qty

Loc Code

FP001

250

116582

5

117291

2

117887

53

119623

36

120910

4

121166

100

121259

50

121584 ✓

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 82686

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

82686

D350-636-012

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

517.0000

4

4

AN3C6A

BOLT

**

4

(DP) 12/05/04

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

516

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

27

120693 ✓

400

NAS1149C0832R

Purchased

No

230

Each

295.0000

1

1

NAS1149C0832R

WASHER

**

1

(DP) 12/05/04

Location

Loc Qty

Loc Code

ST297

295

114915 ✓

295

D3536-25

Manufactured

No

230

Each

22.0000

1

1

D3536-25

Gasket

**

1

(DP) 12/05/04

Location

Loc Qty

Loc Code

FP

14

81342

14

FP002

8

78902

8

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 82686

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

82686

D350-636-012

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

23.0000

1

1

D3794-3

Gasket

**

1 (2P) 12/05/04

Location

Loc Qty

Loc Code

FP002

83396✓

23

74530

2

80436

21

AN3C5A

Purchased No

230

Each

1,602.000

34

34

AN3C5A

Bolt

**

34 (2P) 12/05/04

Location

Loc Qty

Loc Code

FP001

121444✓

7

115835

7

ST350

1595

116419

28

117343

13

117764

7

117872

2

119749

23

120423

522

1210168

500

121255

500

D3537-1

Manufactured No

230

Each

26.0000

3

3

D3537-1

Wearpad

**

3 (2P) 12/05/04

Location

Loc Qty

Loc Code

FG

81959✓

10

79833

10

FP002

16

69817

5

80337

11

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 82686

82686

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

22.0000

1

1

D3535-25

Wearshoe

**

1

(2P)

12/05/04

Location

Loc Qty

Loc Code

FP001

82156✓

22

62233

1

80331

10

81357

11

D3492-3

Manufactured No

230

Each

1.0000

8

8

D3492-3

Plug

**

8

(2P)

12/05/04

Location

Loc Qty

Loc Code

FP-A

83099✓

1

78600

1

AN960C10L

✗

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38

*AN960C10I *

washer

121509✓

**

38

(2P)

12/05/04

D3488-042

Manufactured No

230

Each

16.0000

1

1

D3488-042

Blade Fitting Assembly, RH

**

1

(2P)

12/05/04

Location

Loc Qty

Loc Code

FP002

16

62003

1

75068

8

77015

7

B83C117

VI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 82686

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

82686

D350-636-012

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

2,477.000

38

38

AI S4-1032-225

Insert

**

38

28 12/05/04

Location

Loc Qty

Loc Code

ST281

2454

108696

146

110768

62

118386

55

118966

68

120671

123

121269 ✓

2000

ST282

23

120410

10

120451

13

D3492-1

Manufactured

No

230

Each

46.0000

8

8

D3492-1

Plug

**

8

28 12/05/04

Location

Loc Qty

Loc Code

FP002

46

69531

8

74444

2

76235

4

77037

32

D3793-1

Manufactured

No

230

Each

26.0000

1

1

D3793-1

Wearshoe

**

1

28 12/05/04

Location

Loc Qty

Loc Code

FP001

26

78901

10

82171

16

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Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 82686

82686

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

64.0000

8

8

D2745

Bushing

**

8 (2P) 12/08/04

Location

Loc Qty

Loc Code

FP

81964 ✓

62

79518

62

FP001

2

69529

1

76142

1

AN6C44A

Purchased

No

230

Each

175.0000

4

4

AN6C44A

BOLT

**

4 (2P) 12/05/04

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

173

120143

25

120465

27

120641

1

121013

20

121167 ✓

100

D3532-1

Manufactured

No

250

Each

55.0000

2

2

D3532-1

Spacer

**

12/4/25

Location

Loc Qty

Loc Code

ST053

55

78839

31

82041

24

82041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 82686

82686

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

115.0000

2

2

MS21083C8

NUT

**

M/21349

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

6

115884

0

118077

1

119309

2

119436

1

119638

2

ST304

58

120142

8

120731

25

121011

25

NAS1149D0863J

Purchased

No

250

Each

219.0000

2

2

NAS1149D0863.J

WASHER

**

M/20308

Location

Loc Qty

Loc Code

ST298

219

118078

36

119307

83

120308

100

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Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 14

Work Order ID: 82686

82686

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

54.0000

2

2

D3493-1

Washer

**

83097

Location

Loc Qty

Loc Code

ST050

54

70697

2

77573

12

78835

40

AN8C21A

Purchased

No

250

Each

79.0000

2

2

AN8C21A

BOLT

**

M72/275

Location

Loc Qty

Loc Code

ST343

79

118758

5

120094

34

121067

20

121167

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT

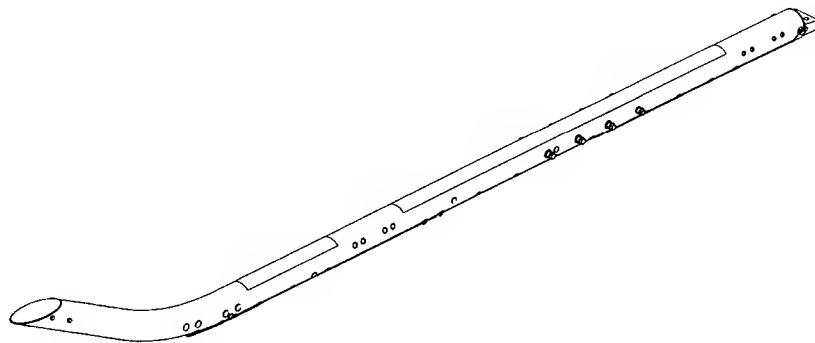
WITHOUT NOTICE
WORK ORDER

NO. 82686 MLJ
12/04/05

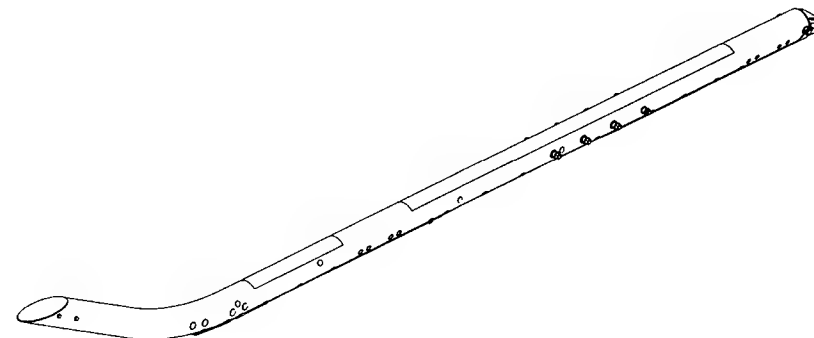
RELEASED

F	INCORPORATE DSI 9413, QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON REF NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEQ 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RA		
CHECKED	AL	DRAWING NO.	REV. F
MFG. APPR.	AL	D2750	SHEET 1 OF 11
APPROVED	AL	TITLE	SCALE
DE APPR.	AL	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

82686



D2750-041 350 SKIDTUBE ASSEMBLY, LH

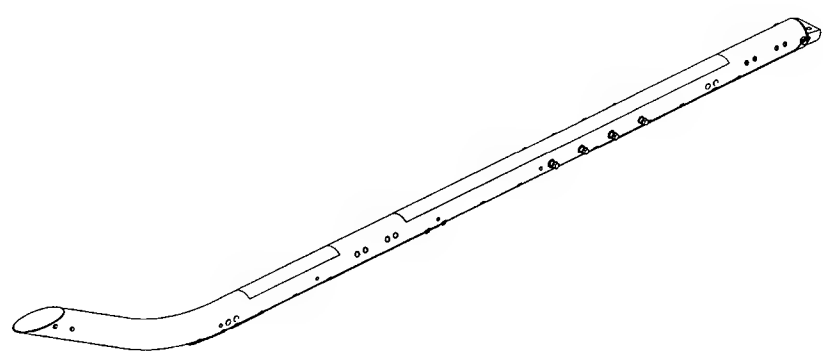


D2750-042 350 SKIDTUBE ASSEMBLY, RH

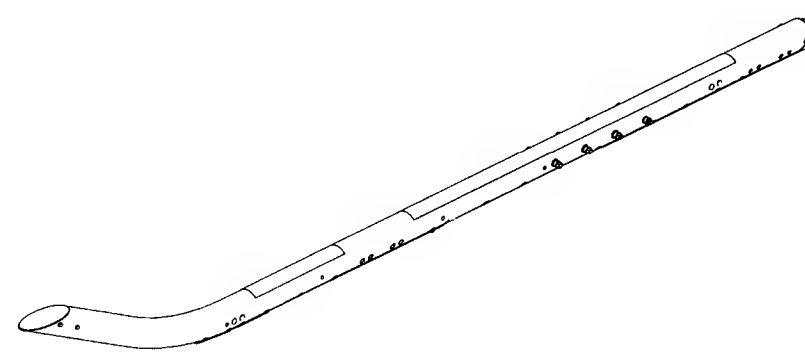
RELEASED
158 9.22.14

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG APPR.	MA	D2750	SHEET 2 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

82686



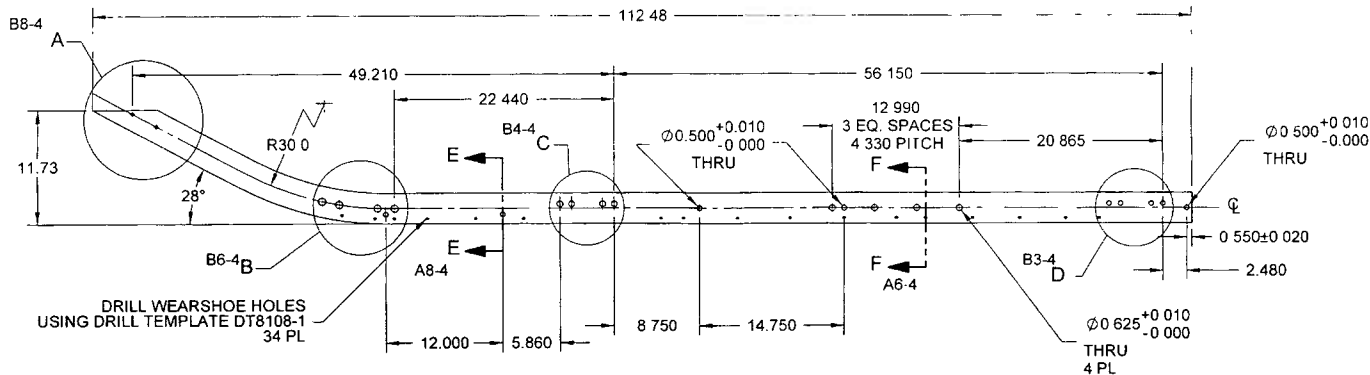
D2750-043 350 SKIDTUBE ASSEMBLY, LH



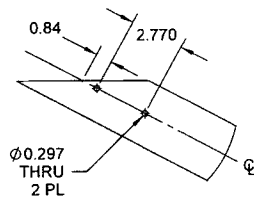
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-09-12/14

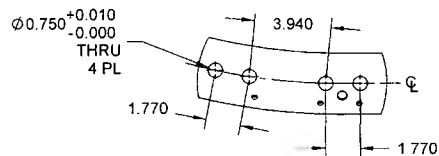
DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR	SA	D2750	SHEET 3 OF 11
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



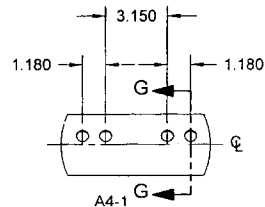
D2750-1 LH SKIDTUBE



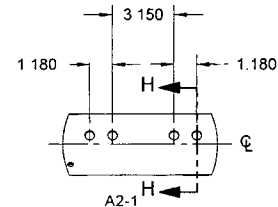
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SCALE 2X



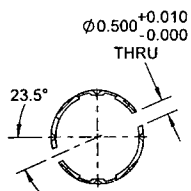
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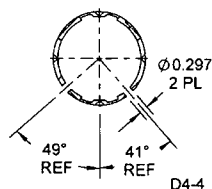
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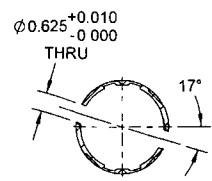
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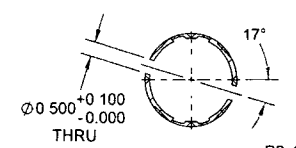
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

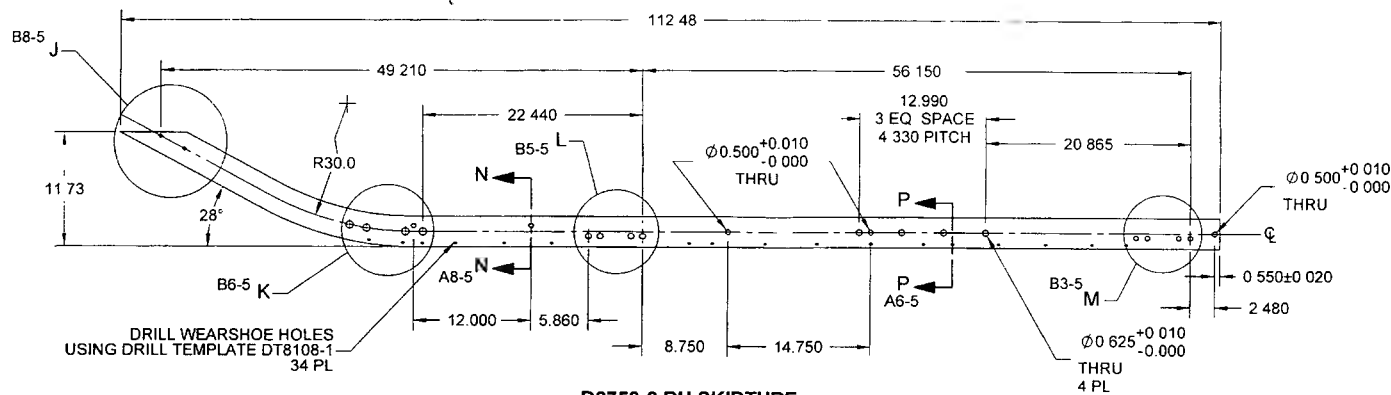


SECTION H-H
SCALE 3X, 4 PL

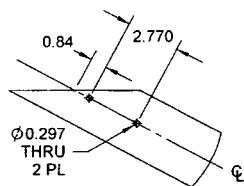
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DRAWN	1/1
CHECKED	1/1
MFG. APPR.	1/1
APPROVED	1/1
DE APPR.	1/1
DATE	08.07.16

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F SHEET 4 OF 11
TITLE 350 SKIDTUBE ASSEMBLY	
SCALE NTS	
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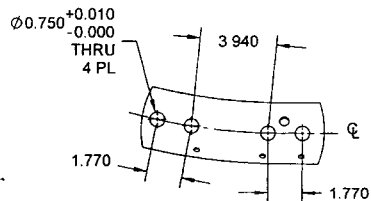
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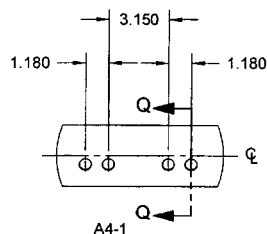
D2750-2 RH SKIDTUBE



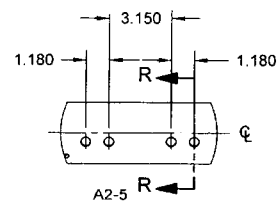
DETAIL J
SCALE 2X



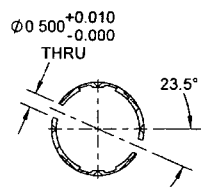
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SCALE 2X



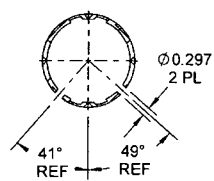
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SCALE 2X



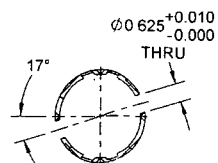
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SCALE 2X



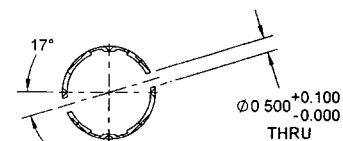
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



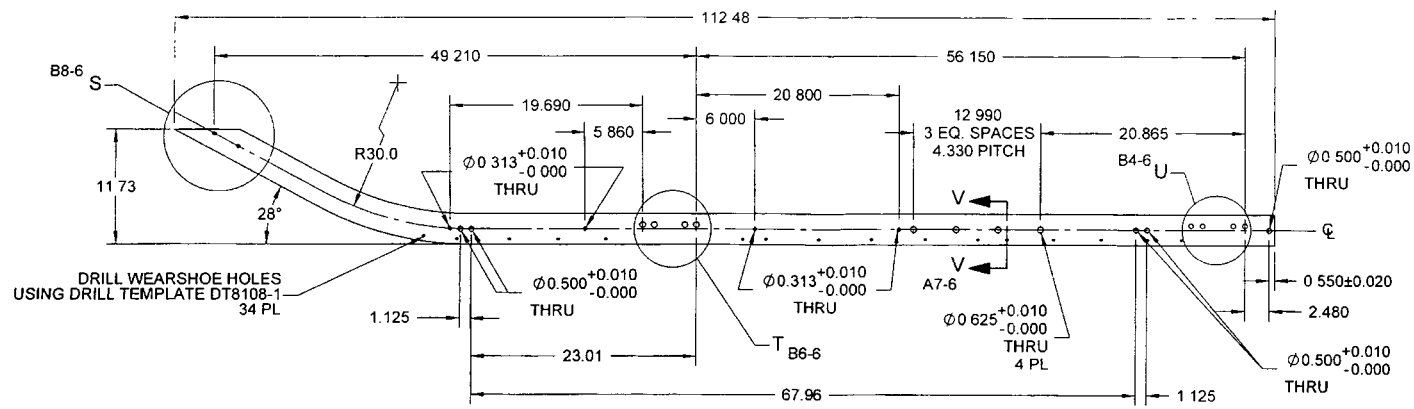
SECTION Q-Q
SCALE 3X, 4 PL



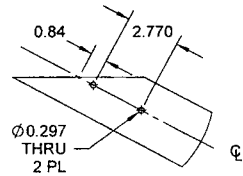
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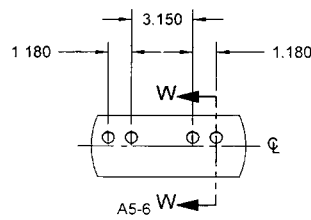
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DRAWN	PEL	PORT HADLOCK, WA	
CHECKED	PEL	DRAWING NO.	REV. F
MFG. APPR.	PEL	D2750	SHEET 5 OF 11
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DE APPR.	PEL	350 SKIDTUBE ASSEMBLY	NTS
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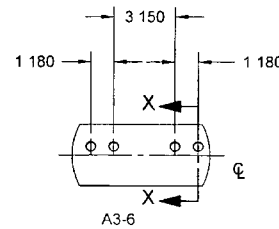
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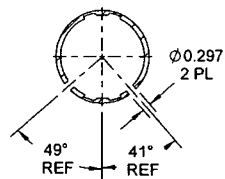
DETAIL S
SCALE 2X



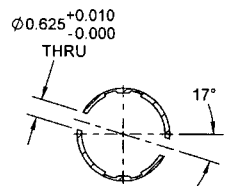
DETAIL T
SCALE 2X



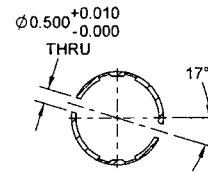
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



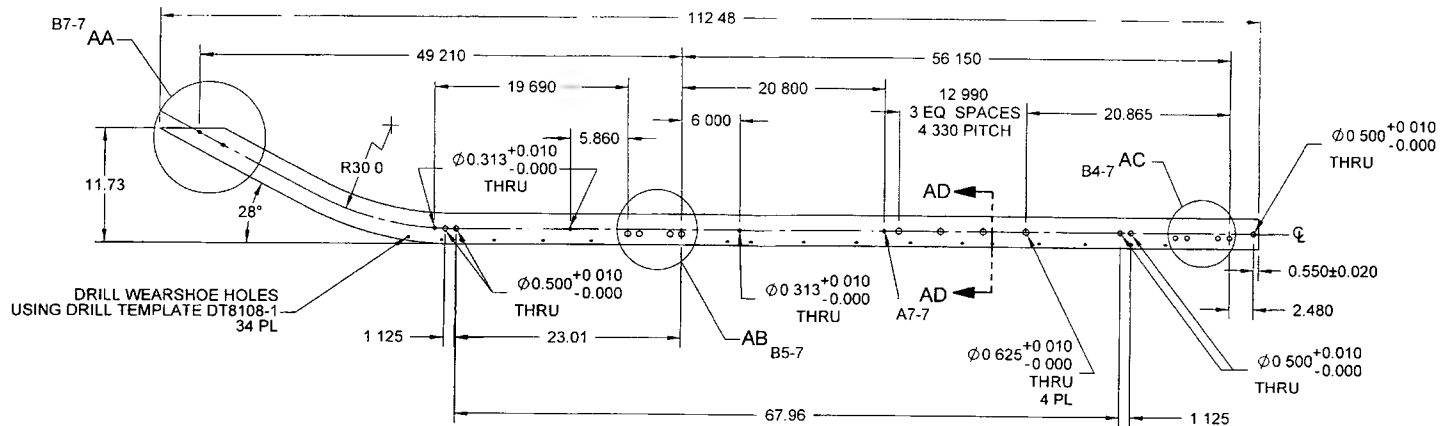
SECTION W-W
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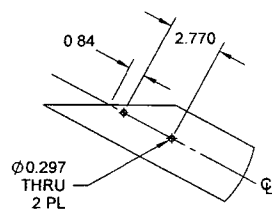
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RELEASED
06-22-11

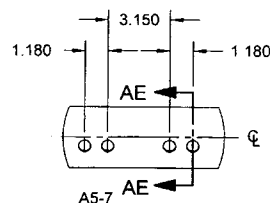
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MFG. APPR.		D2750	SHEET 6 OF 11
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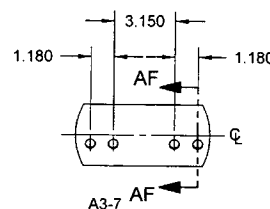
D2750-4 RH SKIDTUBE



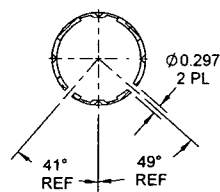
DETAIL AA
SCALE 2X



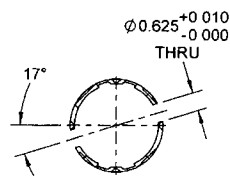
DETAIL AB
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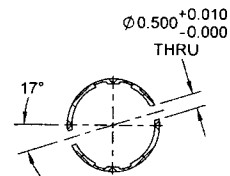
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



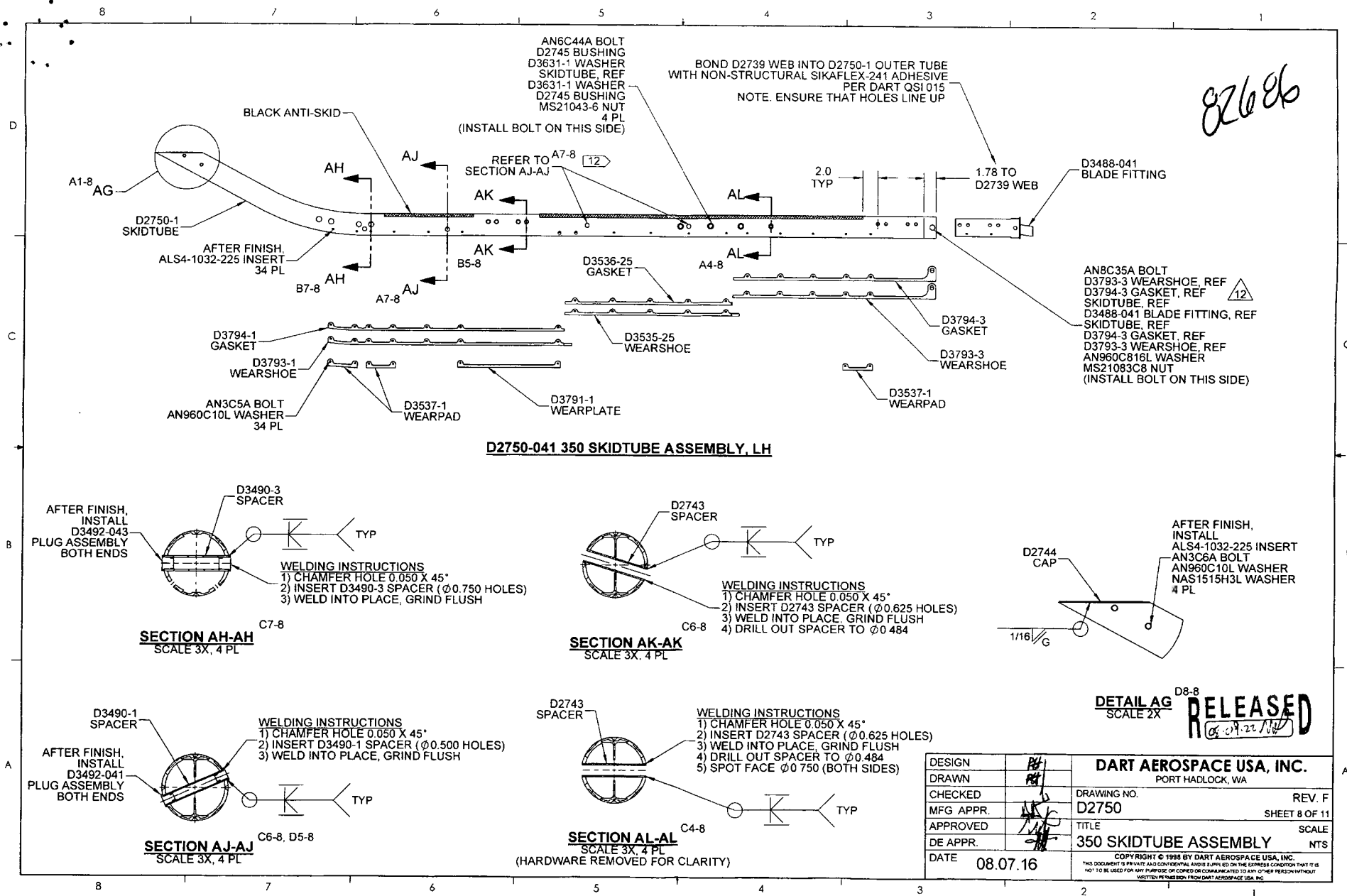
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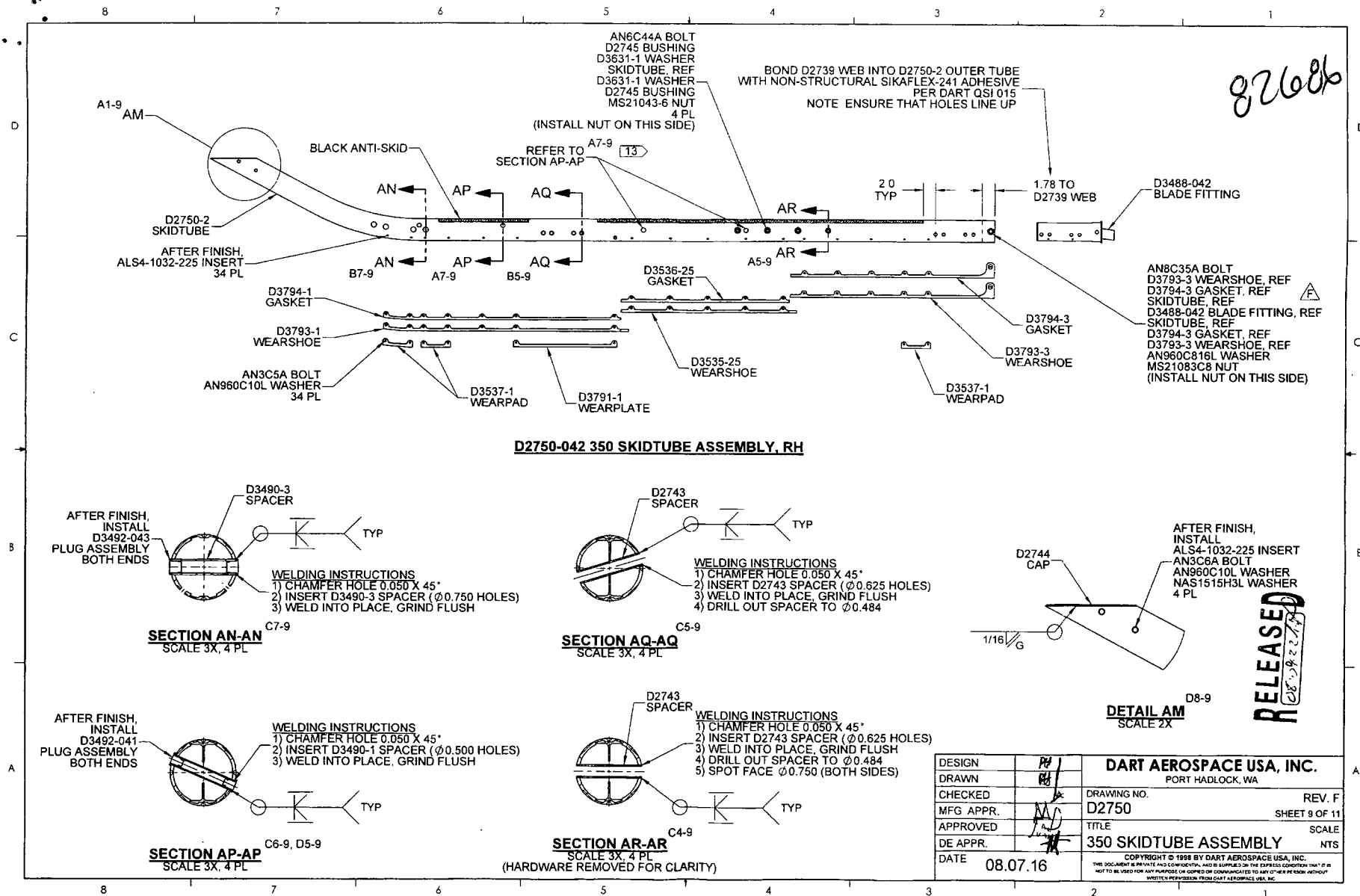
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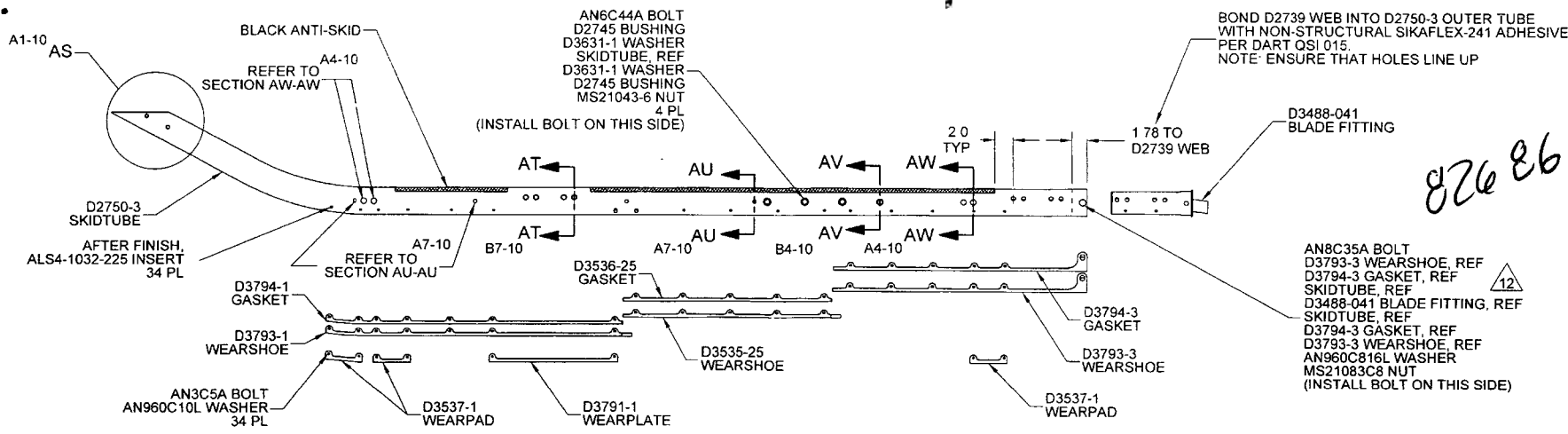
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
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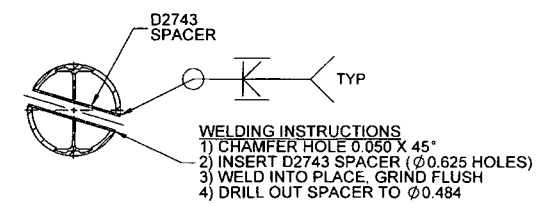
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DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG APPR.		D2750	SHEET 8 OF 11
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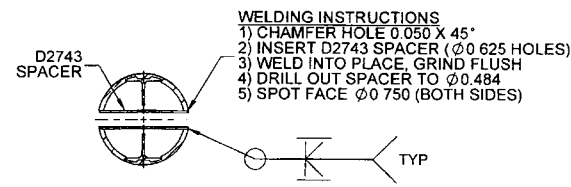
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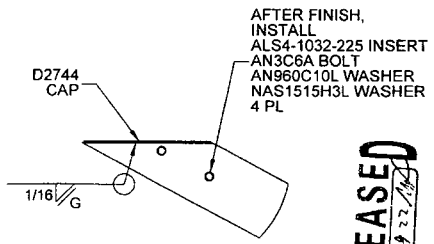
D2750-043 350 SKIDTUBE ASSEMBLY, LH



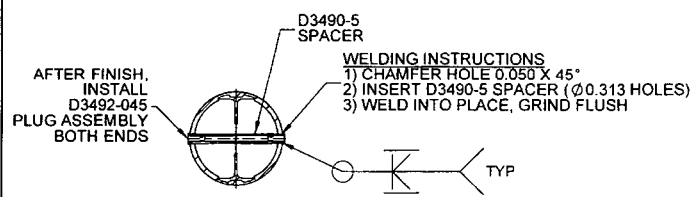
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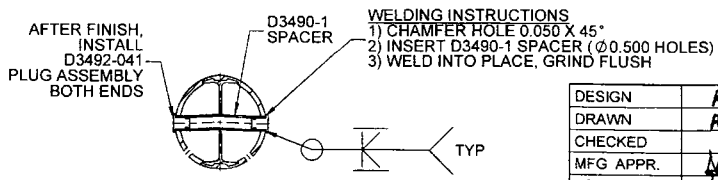
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AS
SCALE 2X



SECTION AU-AU
SCALE 3X, 4 PL

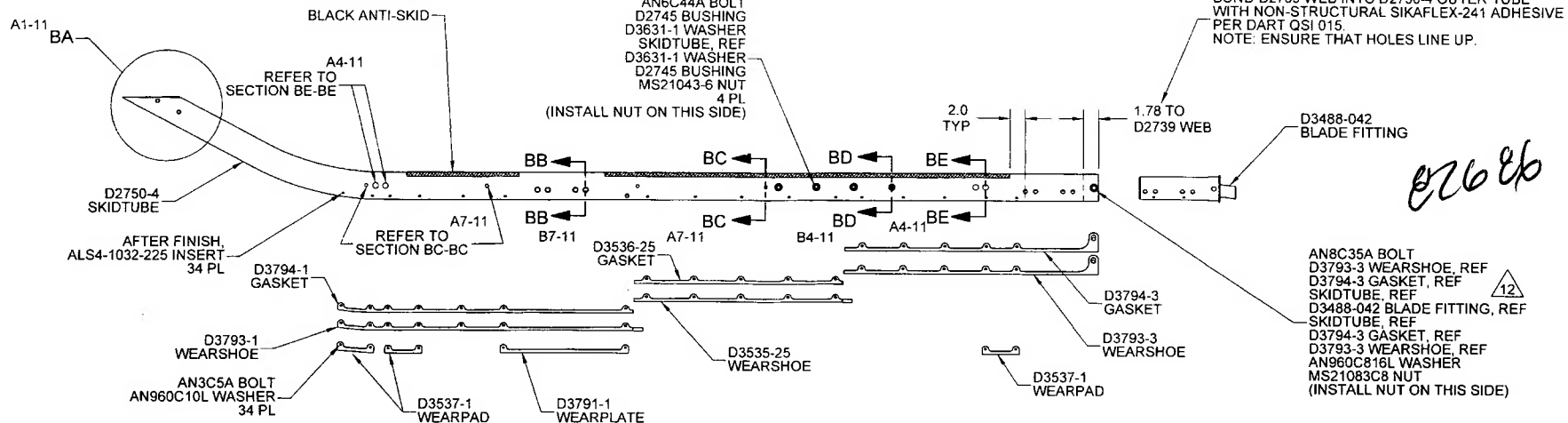


SECTION AW-AW
SCALE 3X, 4 PL

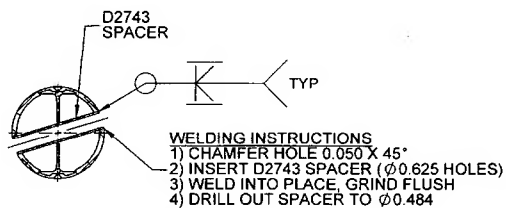
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DRAWN	10	PORT HADLOCK, WA	
CHECKED	10	DRAWING NO	REV. F
MFG APPR.	10	D2750	SHEET 10 OF 11
APPROVED	10	TITLE	SCALE
DE APPR	10	350 SKIDTUBE ASSEMBLY	NTS
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2015-09-22

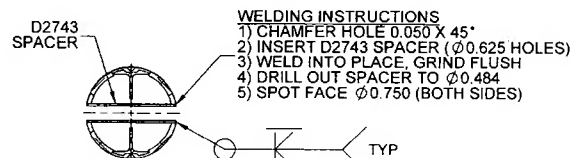
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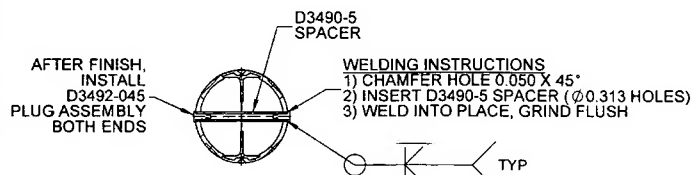
D2750-044 350 SKIDTUBE ASSEMBLY, RH



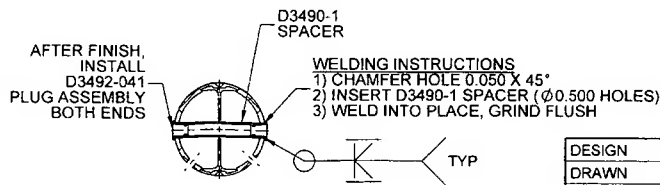
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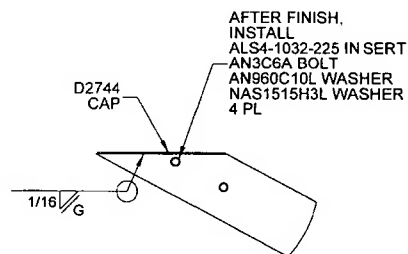
SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC SCALE 3X, 4 PL



SECTION BE-BE SCALE 3X, 4 PL



DETAIL BA SCALE 2X

DESIGN	HA	DART AEROSPACE USA, INC.	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO. D2750	REV. F
MFG. APPR.	HA	SHEET 11 OF 11	
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	350 SKIDTUBE ASSEMBLY	
DATE	08.07.16	NTS	

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NO. 293

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 82796
Part number: A350-636-014
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier David Reed

Date of Test Coupon 12-05-01

Welder Barclay Elliott

Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

